

Work Order ID 75426

75426

Page 1

Friday, October 21, 2011 2:22:27 PM

Item ID: D206-642-151

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 10/21/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

0.00

0.00

100.

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A on 12/01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan: _____

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Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M117889

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

SAD 11-11-29

BE11-11-29

SAD

11-14-29

OK 11/12/01

OK 11/12/02

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

DL
11/12/02DL
11/12/02

11 12 02 (1)

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC6- Inspect dimensions to drawing	0.00							
170						1	0	BE 11-12-05	
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required								
	2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting								
	Start Date: 11-12-5 Time: 5PM								
	Finish Date: 11-12-06 Time: 2:30								
	Pick:								
	Qty Part Number Description Batch								
	A/RSikaflex-291 119359								
	Sikaflex expire date 2-8-13								

SAN 11-12-05

DP 11-12-5

W/O:		WORK ORDER CHANGES					
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Start Date: 10/21/2011 Start Qty: 1.00

1

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Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

1 BF 11-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100Setup Start ***NS1***

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Item Name: Replacement Skidtube

Start Date: 10/21/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
200									
Skidtubes		0.00							
Skidtubes	Memo 1-remove alodine from around hole and prepare for welding 2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: QtyPart NumberDescriptionBatch A/RAluminum Rod <u>11117689</u> 3-Grind welds flush as per Dwg D3804. <u>11/12/06</u> 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/RSS Rod <u>NONE</u> <u>11-12-06</u> 5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75426

Friday, October 21, 2011 2:22:28 PM

N900040100

Stop ***NS2***

Customer:

Run Start *NR1*

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 75426***75426***

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Start Date: 10/21/2011 Start Qty: 1.00

1

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Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

240

Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320 OF
10:00

Powder Coating

M11A480

1X PM 11/12/10

1X PM 11/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 75426

Friday, October 21, 2011 2:22:28 PM

75426

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N900040100

Setup Start

NS1

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Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00				164	0	24	11/12/11
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00				164	0	24	11/12/11
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install ✓ plugs as per Dwg D3804. Clean excess adhesive.								

LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

Setup Start *NS1*

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Start Date: 10/21/2011 **Start Qty:** 1.00

*** 1 ***

Customer:

Required Date: 11/2/2011 **Req'd Qty:** 1.00

*** 1 ***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

280

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

✓ 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/RSikaflex-291 1111443
Sikaflex expire date: 12/01

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4
Batch: 11119094

290

QC3- Inspect Part Finish

0.00

290

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

310

Packaging

0.00

310

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location: _____

PPP Rev: _____

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

M.L.J 11/12/29

(1)

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Picklist Print

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Page 1

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75426

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC
REV:B 11.09.16 PER IIN REV:O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	13.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2620

Skidtube, 206 Skidtube

**

SAD

11-11-29

Location

Loc Qty

Loc Code

LG

13

71616

3

71617

6

73783

1

73785

1

73786

2

D2647		Manufactured	No			110	Each	197.0000	1	1			
-------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D2647

Cap

**

B75426

D

2E11-11-29

Location

Loc Qty

Loc Code

LG002

197

55352

4

71171

10

73826

183

1

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

18,861.00

52

52

CR3212-4-04

Cherry Rivet

**

SAD 11-12-05

Location

Loc Qty

Loc Code

ST311

150

116471

78

117816

3

118686

1

118840

68

st510

10000

119075

10000

ST516

8711

119017

8711

52

D2654-1

Manufactured

No

180

Each

3.0000

1

1

D2654-1

Web

**

DP 11-12-5

Location

Loc Qty

Loc Code

LG

3

75475
73794

3

①

DP 11-12-5

D3286-1

Manufactured

No

180

Each

108.0000

2

2

D3286-1

Doubler

**

2 11/12/02

Location

Loc Qty

Loc Code

LG002

108

74111

20

74441

88

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:22:32 PM

Page 3

Work Order ID: 75426

75426

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,146.000

19

19

D2649

Cross Bolt Spacer

**

BE 11-12-06
B 73859 - 19

Location

Loc Qty

Loc Code

LG

617

68224

2

71355

2

72704

2

72841

11

73855

600

LG001

529

65317

1

68507

11

73390

8

73857

21

73860

488

D3286-3

Manufactured No

200

Each

97.0000

2

2

D3286-3

Spacer

**

BE 11-12-06
B 75483 72

Location

Loc Qty

Loc Code

LG001

97

74117

17

74439

80

D2680-041

Manufactured No

210

Each

99.0000

1

1

D2680-041

Nut Plate

**

DP 11-12-6

Location

Loc Qty

Loc Code

LG

4

73334

4

ST020

95

73854

95

①

Friday, October 21, 2011 2:22:32 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:22:32 PM

Page 4

Work Order ID: 75426

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

75426

D206-642-151

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03 Purchased No

210 Each

2,010.000

2

2

CR3212-4-03

Cherry Rivet

**

DP 11-12-6

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1008

114859

1008

ST318

1000

119017

1000

(2)

AN960D416 NAS1149D0463J Purchased No

210 Each

0.0000

1

1

AN960D416

Washer

**

1118384 (x1) 11/12/11

CCR264SS3-3 Purchased No

210 Each

1,285.000

2

2

CCR264SS3-3

Cherry Rivet

**

DP 11-12-6

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

283

117849

283

ST317

1000

119017

1000

(2)

MS27039-4-06 Purchased No

210 Each

433.0000

1

1

MS27039-4-06

Screw

**

11/12/11

Location

Loc Qty

Loc Code

ST292

433

119075

400

119124

33

V1

Friday, October 21, 2011 2:22:32 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:22:32 PM

Page 5

Work Order ID: 75426

75426

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

270

Each

1,063.000

6

6

D2651-1

Plug

**

11/12/14

Location

Loc Qty

Loc Code

fpa

2

69018

2

FP-A

1061

57869

1

66445

10

70839

2

71037

31

73827

1017

✓

D2651-3

Manufactured No

270

Each

1,547.000

6

6

D2651-3

O-Ring

**

11/12/14

Location

Loc Qty

Loc Code

FP-A

1547

61962

12

66956

30

73489

505

73828

1000

✓

D3873-1

Manufactured No

280

Each

342.0000

14

14

D3873-1

Bushing

**

1373832 (✓) 11/12/14

Location

Loc Qty

Loc Code

ST088

342

64760

1

68247

4

73829

19

73831

318

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:22:32 PM

Page 6

Work Order ID: 75426

75426

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280 Each

91.0000

1 1

D2646

Aft Cap

**

B73825(x) M 11/2/11

Location

Loc Qty

Loc Code

FP002

60

73294

60

FP004

17

68280

17

FP006

5

62678

5

FP-4

5

70945

1

71070

4

fp5

4

71038

4

D3805-041

Manufactured No

280 Each

0.0000

1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280 Each

1,971.000

2 2

MS27039-1-08

Screw

**

M 11/2/11

Location

Loc Qty

Loc Code

ST291

1971

117423

155

118378

316

118910

500

119075

500

119109

500

v7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:22:32 PM

Page 7
8

Work Order ID: 75426

75426

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

9,976.000

7

7

MS21042L3

Nut

**

4112101

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927

694

ST516

6000

119017

6000

ST518

3000

119075

3000

✓

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

75499

**

1 Bl 11-12-20

Location

Loc Qty

Loc Code

FP

5

73817

5

AN960JD10L

NAS1149D0332L

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

11118389 (x2) 4112101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Friday, October 21, 2011 2:22:32 PM

Work Order ID: 75426

75426

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280

Each

2,319.000

7

7

AN3-37A

Bolt

**

u u l r l d

Location

Loc Qty

Loc Code

ST353

269

111668

169

118628

100

ST354

50

117619

50

ST518

2000

119086

2000

x 7

NAS1149D0363J

Purchased

No

280

Each

2,836.000

7

7

NAS1149D0363.J

Washer

**

u u l r l e

Location

Loc Qty

Loc Code

ST298

2836

117601

218

118077

135

118612

483

118968

2000

x 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75426

11-10-21

RELEASED
09.03.03
per ECA 09-538

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>99</i>	DART AEROSPACE USA, INC	
DRAWN	<i>99</i>	PORT HADLOCK, WA	
CHECKED	<i>99</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>99</i>	D3804	SHEET 1 OF 5
APPROVED	<i>99</i>	TITLE	SCALE
DE APPR.	<i>99</i>	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a mechanical part, likely a shaft or tube, showing dimensions and details. The drawing includes a side view with a curved end and a cross-sectional view. Key dimensions include a total length of 104.1, a bend radius of R30.0±1, and various diameters and hole specifications. Details A and B are highlighted with dashed circles and labels. A note states "NO CBORE THIS HOLE ON EITHER SIDE". The drawing is labeled with "RE" and "RO" in the top right corner.

Dimensions:

- Overall Length: 104.1
- Distance from Reference to Bend Tangent: 87.0
- Distance from Reference to End: 17.1
- End Radius: R30.0±1
- Distance from End to Detail A: 78.04
- Distance from Detail A to Detail B: 68.50
- Distance from Detail B to End: 15.50
- Distance from Detail A to Centerline: 63.50
- Distance from Detail B to Centerline: 53.500
- Distance from Centerline to End: 10.00
- Distance from Detail A to Hole: 30.900
- Distance from Hole to End: 5.00
- Distance from Detail A to Hole: 23.175
- Distance from Hole to End: 14.87
- Distance from Detail A to Hole: 15.450
- Distance from Hole to End: 6.500
- Distance from Detail A to Hole: 7.725
- Distance from Hole to End: 3.975
- Distance from Detail A to Hole: 5.225
- Distance from Hole to End: 2.00 TO WEB

Details:

- DETAIL A C7-S**: Located at the end of the part, showing a cross-section with a hole.
- DETAIL B C5-S**: Located near the bend, showing a cross-section with a hole.

Notes:

- NO CBORE THIS HOLE ON EITHER SIDE
- Ø0.375 THRU 20 PL
- 7.00 FLAT
- 21.00^{+0.030}_{-0.000}

Technical drawing of a truck chassis component, likely a rear axle assembly, showing dimensions and details. The drawing includes labels for "DETAIL E A7-5", "DETAIL F B2-5", "MASK THREADS IN D2680-041 BEFORE APPLYING FINISH REF DETAIL E", "FINISH HOLES PER SECTION D-D", "ANTI-SKID PAINT 3 PL", and "D". Dimensions include 1.5, 12.0, 0.5, 15.5, 12, and A6-5 D. A section line D-D is indicated.

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 3 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NT
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PREPARED BY OR FOR THE USE OF THE CUSTOMER. IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

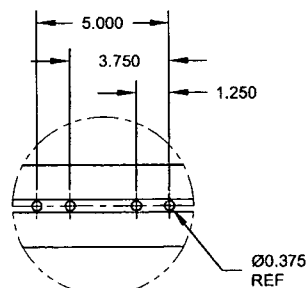
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

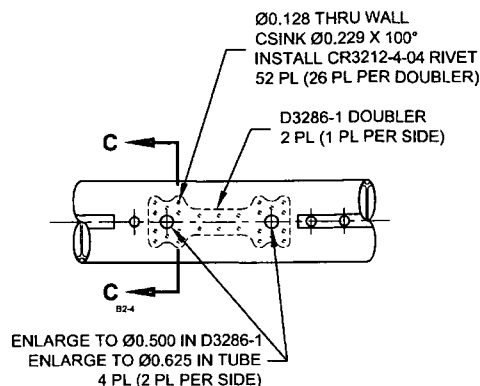
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
UP 09.05.07



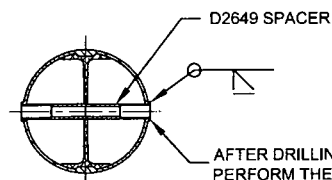
DETAIL A D6-2
SCALE NONE C2-2
D6-3
C2-3



DETAIL B C3-2
SCALE NONE C3-3

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY A4-3
SCALE NONE

75426

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D3804	SHEET 2 OF 5
APPROVED	1	TITLE	SCALE
DE APPR.	1	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

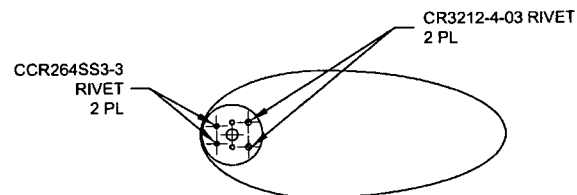
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

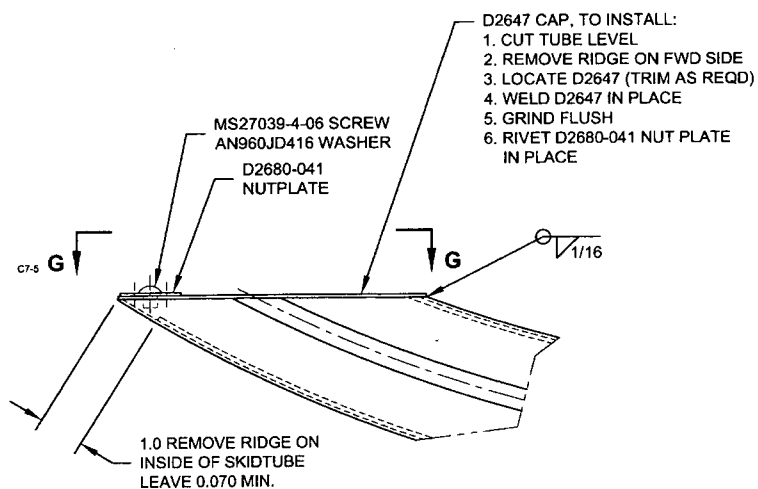
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

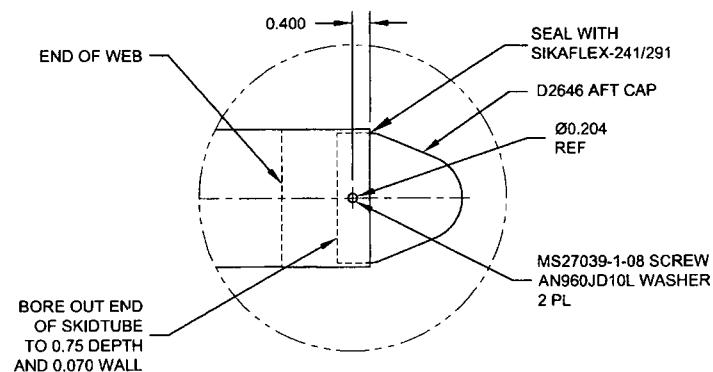
RELEASED
91 09.03.03



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2
B7-3



DETAIL F
SCALE NONE B2-2
B2-3

75424

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 5 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 274

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 75391
Part number: 206 642 151
Description: 206 skid tube
Welding Process: Tig~~[]~~ Mig~~[]~~
Base material: Aluminum
Current: AC~~[]~~ DC~~[]~~

TEST REQUIREMENTS AND RESULTS

Visual: pass~~[]~~ fail~~[]~~
Penetration: pass~~[]~~ fail~~[]~~

UNACCEPTABLE

Cracks: pass~~[]~~ fail~~[]~~
Undercut: pass~~[]~~ fail~~[]~~
Pin holes: pass~~[]~~ fail~~[]~~
Overlap (cold lap): pass~~[]~~ fail~~[]~~
Porosity (surface): pass~~[]~~ fail~~[]~~
Coloration: pass~~[]~~ fail~~[]~~

Qualifier Sal Kurn Date of Test Coupon 11-11-18

Welder John Smith Date of Test Coupon 11-11-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld